

Work Order ID 155065

Friday, January 06, 2017 10:58:15 AM

for flight test
155065

Page 1

Item ID: D5355-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Clamp Assembly
Start Date: 01/06/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 01/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan *[Signature]* Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: *[Signature]* Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D5355	B								
100	BAND SAW	0.01				4	0		DAS 14 9-89 17/01/07
100									
Bandsaw	Memo	0.06							
Jeaspa Bandsaw	Cut Blanks at 6.200"								
110	HAAS CNC VERTICAL MACHINING #1	0.01				4	0		DAS 14 9-89 17/01/07
110									
HAAS 5 AXIS	Memo	0.22							
HAAS CNC vertical machine #5	1-Machine per folio FB434 DWG REV: <i>B</i> FOLIO REV: <i>AA</i>								
2- deburr and break all sharp edge as per dwg									

Work Order ID 155065***155065***

Page 2

Friday, January 06, 2017 10:58:15 AM

Item ID: D5355-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Clamp Assembly
Start Date: 01/06/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 01/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.01				<u>4</u>	<u>0</u>		DAS 14 9-89 17/01/07
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.01				<u>4</u>	<u>0</u>		DAS 44 9-89 17-01-09
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : _____ Black Anodize as per Dwg D5355 Certification of Conformity is required.	0.00 48.00							

N/A
17-01-06

Work Order ID 155065

Friday, January 06, 2017 10:58:15 AM

155065

Page 3

Item ID: D5355-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Clamp Assembly
Start Date: 01/06/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 01/18/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo Certification of Conformity is required.	0.00 0.01				_____	_____	_____	_____
155 *155* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				_____	_____	_____	_____

n/a *Full* *17 01.06*

Work Order ID 155065***155065***

Page 4

Friday, January 06, 2017 10:58:15 AM

Item ID: D5355-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Clamp Assembly

Start Date: 01/06/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 01/18/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.01

160

Small Fab

Small Fab

Memo

-Assemble as per dwg.

-Secure nuts as per dwg. (Note #8)

-Apply proseal as per dwg.

Batch: 136076Exp. date: 5/17

0.11

4 FF JAN 12 2017

170

0.00

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.01

DAS
16
9-89(Y4) 12/12/13
REV B

20-17-106-01

[Signature]

JAN 13 2017

POSITIVE RECALL

EFFECTIVE 12.01.11 AUTH 9

RELEASED _____ DATE _____

DAS
9
8-89

flight test

Page 5

Quality Control

Picklist Print

Page 2

Friday, January 06, 2017 10:58:14 AM

Work Order ID: 155065

155065

Parent Item: D5355-041

D5355-041

Parent Item Name: Aft Clamp Assembly

Start Date: 01/06/2017

Required Date: 01/18/2017

Start Qty: 4.00

Required Qty: 4.00

MS21043-3	Purchased	No	160	Each	1,352.000	2	8	
MS21043-3						**		
Nut								
								DAS 30 9-89 JAN 12 2017

Location	Loc Qty	Loc Code
CCK007	361	
m135864	361	
FG	80	
103691	80	
FP001	403	
m130673	11	
m136182	392	
GA	39	
m133990	39	
ST302	400	
m136295	400	8
ST304	69	
m131340	69	

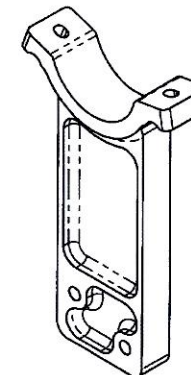
NAS1149D0332J	Purchased	No	160	Each	1,481.000	2	8	
NAS1149D0332.J						**		
Washer								
								DAS 30 9-89 JAN 12 2017

Location	Loc Qty	Loc Code
FP001	92	
m134848	92	
GA	146	
m134848	146	8
ST260a	1200	
m136015	1200	
ST264	43	
m135672	43	

Friday, January 06, 2017 10:58:14 AM

Shop Packet Print

Page 2



NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M8061T6B
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.43 lbs
 - 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5355-1 Rev. B.SLDPRT

RELEASE
2016-06-29

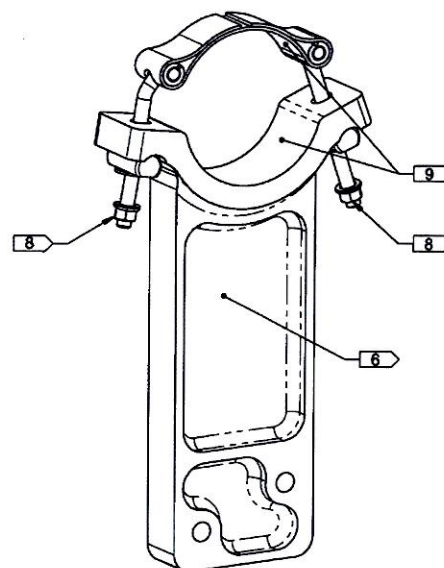
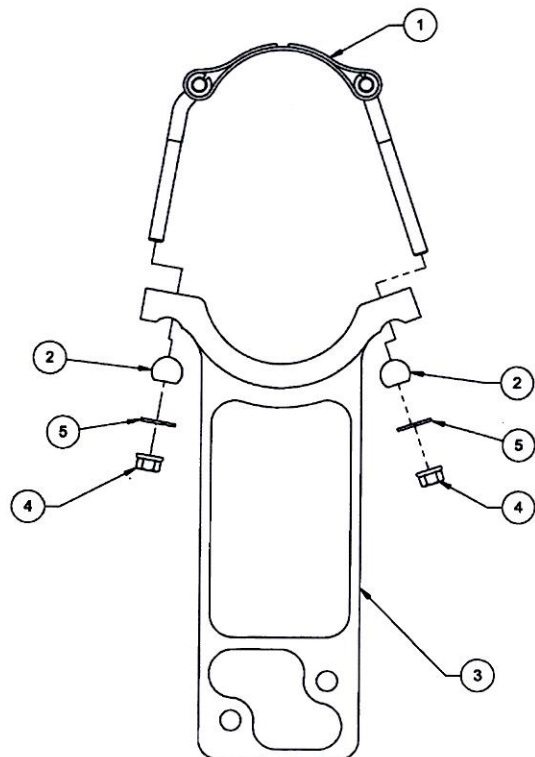
D
APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5355 TITLE R66 AFT CLAMP ASSY COPYRIGHT © 2016 BY DART AEROSPACE LTD. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. EXPRESS PERMISSION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. B
DRAWN	RF		SHEET 2 OF 2
CHECKED	VS		SCALE
MFG. APPR.	JFS		NTS
APPROVED	HS		
DE APPR.	DS		
DATE	16.05.24		

Friday, January 06, 2017 10:58:14 AM

Required Qty: 4.00

[illegible]



ITEM	QTY -041	P/N	DESCRIPTION
	X	D5355-041	R66 AFT CLAMP ASSY
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5355-1	SUPPORT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT

D5355-041 R66 AFT CLAMP ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.51 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

RELEASED
2016-06-29
ECN 16-579

APPROVED

B	REDESIGN -1/-041 (ZN B5-1, B5-2); ADD NOTE 9 (ZN A8-1); REMOVE -043	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	16.05.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5355** REV. B
SHEET 1 OF 2
TITLE **R66 AFT CLAMP ASSY**
SCALE NTS

COPYRIGHT © 2015 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 155065
Description: SUPPORT		Part Number: D5355-1
Inspection Dwg: D5355 Rev: B		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	±.030	1.004	—		Vern 11-06	
.50	±.030	.500	—		"	
Ø.204	±.005	.205	—		"	
.22	±.030	.218	—		"	
.274	±.010	.274	—		"	
.40	±.030	.400	—		"	
20°	± 1/2°	20°	—		C-square	
10°	± 1/2°	10°	—		"	
R.13	±.030	R.125	—		R-6	
.31	±.030	.315	—		Vern 11-06	
.20	±.030	.205	—		"	
.30	±.030	.300	—		"	
5.01	±.030	5.012	—		"	
Ø.257	±.005	Ø.258	—		"	
.500	±.005	.500	—		"	
.50	±.030	.500	—		"	
.40	±.030	.400	—		"	
1.200	±.005	1.200	—		"	
2.000	±.030	2.001	—		"	
R.25	±.030	R.250	—		R-6	
.13	±.030	.123	—		Vern 11-06	
1.28	±.030	1.275	—		"	
.15	±.030	.148	—		"	
.13	±.030	.125	—		"	
.21	±.030	.210	—		"	
R.20	±.030	R.200	—		R-6	
.25	±.030	.250	—		Vern 11-06	
R.13	±.030	R.125	—		R-6	
.150	±.005	.158	—		Vern 11-06	
.250	±.005	.247	—		"	
.65	±.030	.655	—		"	
R.13	±.030	R.125	—		R-6	

Measured by: 14	Checked by: 44	QC Inspector:
Date: 17/01/07	Date: 17-01-09	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	